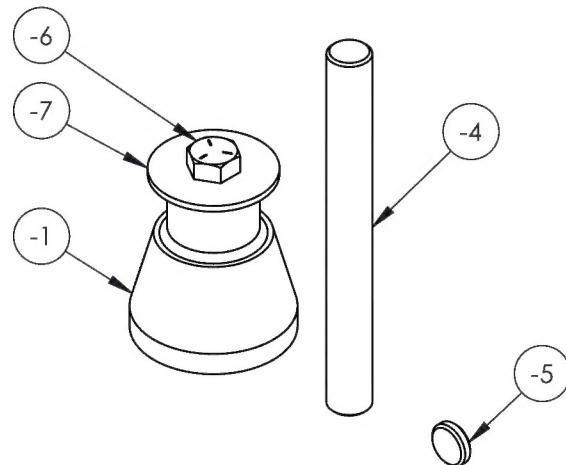


This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		CORRECTED AND COMPLETED FILE. IMPLEMENTED NEW TITLEBLOCK, BOM, & REVISION TABLE. ALSO DELETED OBSOLETE -2 & -3 TOOLS, RBT18531 IS THIER REPLACEMENT SOLD SEPARATELY.			3/5/2008	WP	DW
2	16-0278	UPDATED TO NEW DRAFTING STANDARD. -1, -4, -5 CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, DELETED WORK INSTRUCTIONS. -1 CH'D DIM WAS R.080 IS R.08, WAS .060 X 45° IS .06 X 45°, WAS 5/16-24 UNF DEPTH .625 IS 5/16-24 UNF-2B $\overline{.62}$ . CH'D ENGRAVE NOT WAS ENGRAVE P/N IS ENGRAVE T/N, S/N, "MADE IN USA". -4 CH'D DIM WAS .030 X 45° IS .03 X 45°. ADDED DATUM A AND GD&T FEATURE CONTROL FRAME. -5 CH'D DIM WAS .030 X 45° IS 2X .03 X 45°.			1/11/2017	RJC	JAG

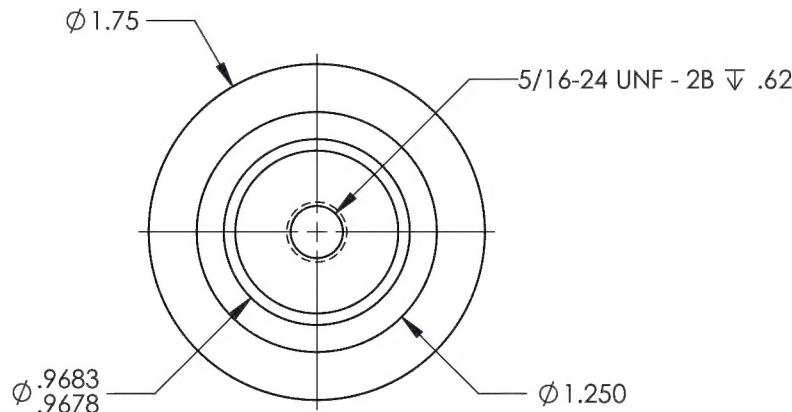
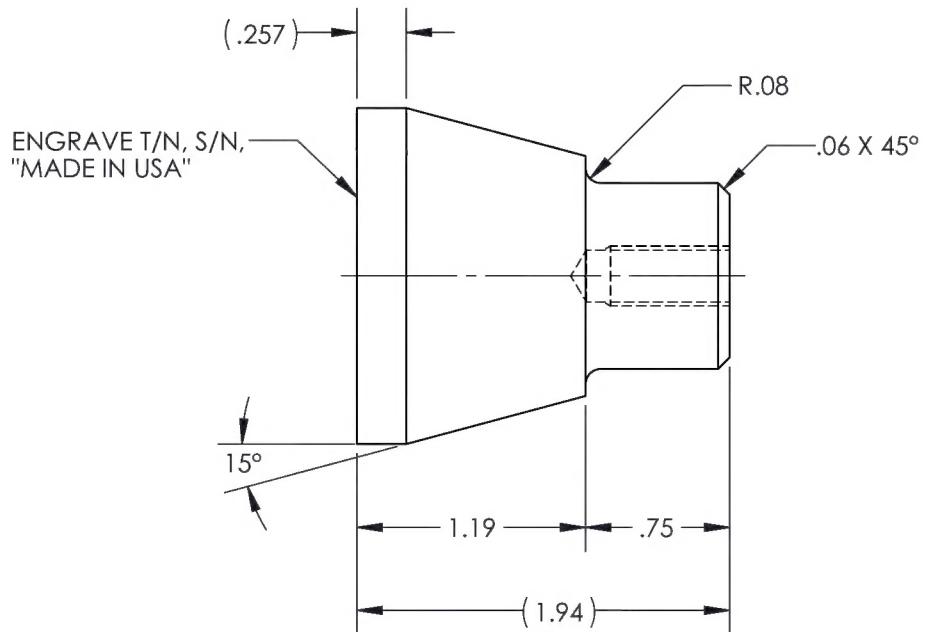
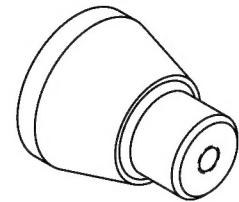


DART AEROSPACE																																							
TITLE T/R TRUNNION CENTERING TOOLS																																							
DWG NO. RBT18517																																							
REV 2																																							
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>HEAT</td> <td>.XXX <math>\pm</math> .005 FRACTIONS <math>\pm</math> 1/8</td> </tr> <tr> <td>TREAT</td> <td>.XX <math>\pm</math> .01 ANGLES <math>\pm</math> 5°</td> </tr> <tr> <td>FINISH</td> <td>X <math>\pm</math> .1 SURFACES = 125</td> </tr> <tr> <td>SPEC</td> <td colspan="2">1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>DRAWN BY:</td> <td colspan="2">COLE</td> </tr> <tr> <td>CHECKED:</td> <td colspan="2">DUPERFELDT</td> </tr> <tr> <td>OPPS APPR:</td> <td colspan="2">ANDERSON</td> </tr> <tr> <td>QA APPR:</td> <td colspan="2">LINDSAY</td> </tr> <tr> <td>APPROVED:</td> <td colspan="2">GILBERT</td> </tr> <tr> <td>SCALE</td> <td>1:2</td> <td>DATE 4/25/2003</td> </tr> <tr> <td colspan="3">USED ON MODEL</td> </tr> <tr> <td colspan="3">BELL 206A &amp; B</td> </tr> <tr> <td colspan="3">SHEET 1 OF 4</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	HEAT	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8	TREAT	.XX $\pm$ .01 ANGLES $\pm$ 5°	FINISH	X $\pm$ .1 SURFACES = 125	SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		DRAWN BY:	COLE		CHECKED:	DUPERFELDT		OPPS APPR:	ANDERSON		QA APPR:	LINDSAY		APPROVED:	GILBERT		SCALE	1:2	DATE 4/25/2003	USED ON MODEL			BELL 206A & B			SHEET 1 OF 4		
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES																																						
HEAT	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8																																						
TREAT	.XX $\pm$ .01 ANGLES $\pm$ 5°																																						
FINISH	X $\pm$ .1 SURFACES = 125																																						
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R																																						
DRAWN BY:	COLE																																						
CHECKED:	DUPERFELDT																																						
OPPS APPR:	ANDERSON																																						
QA APPR:	LINDSAY																																						
APPROVED:	GILBERT																																						
SCALE	1:2	DATE 4/25/2003																																					
USED ON MODEL																																							
BELL 206A & B																																							
SHEET 1 OF 4																																							

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	TRUNNION CENTERING SHAFT	4140/4142		2
			-4	1	TRUNNION INNER RACE REMOVAL PLUG	4140/4142		3
			-5	1	TRUNNION BEARING RACE PLUG	4140/4142		4
		B/O	-6	1	BOLT	STEEL	AN5-4A	1
		B/O	-7	1	WASHER	STEEL	AN970-5	1

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0278	-1 CH'D DIM WAS R.080 IS R.08, WAS .060 X 45° IS .06 X 45° WAS 5/16-24 UNF DEPTH .625 IS 5/16-24 UNF-2B $\nabla$ .62, CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, CH'D ENGRAVE NOT WAS ENGRAVE P/N IS ENGRAVE T/N, S/N, "MADE IN USA", DELETED WORK INSTRUCTIONS.	1/11/2017	RJC	JAG



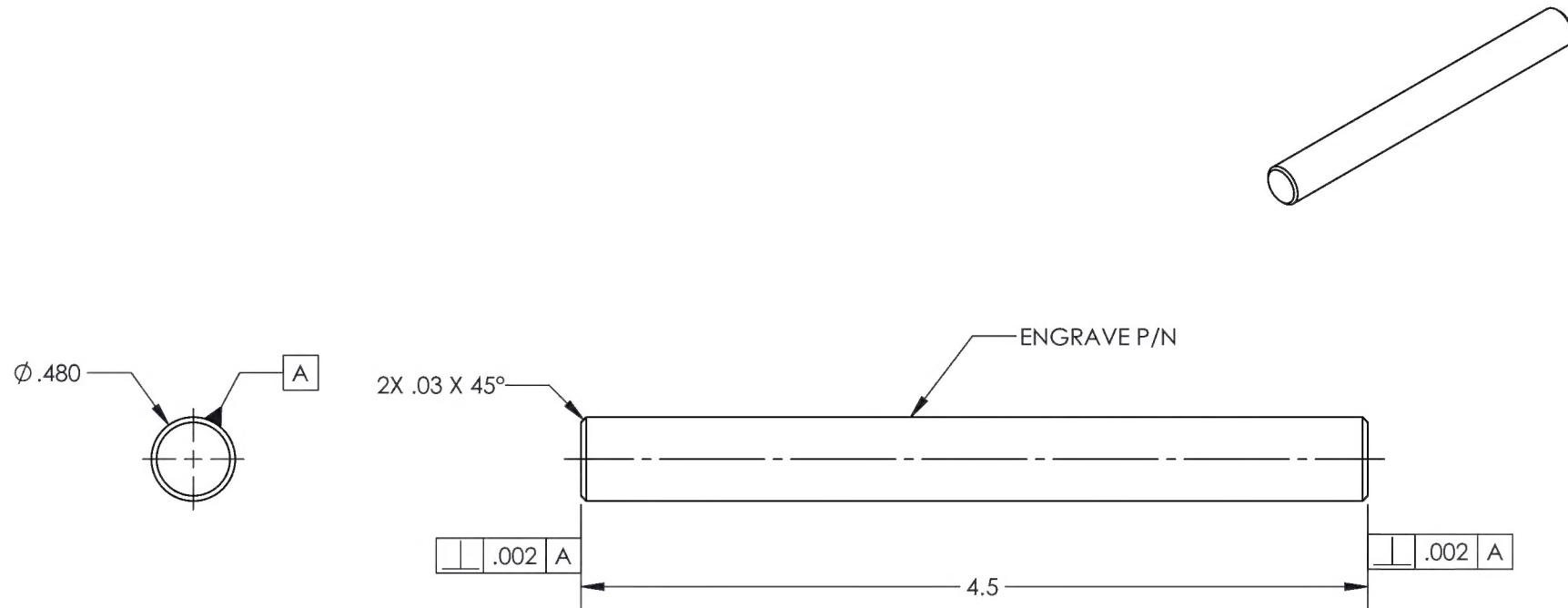
TRUNNION CENTERING SHAFT

(-1)

DART AEROSPACE	
TITLE	
T/R TRUNNION CENTERING TOOLS	
DWG NO.	
RBT18517-1	
REV 2	
MATERIAL 4140/4142	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
TREAT	.XX $\pm$ .01 ANGLES $\pm$ 5°
FINISH	X $\pm$ .1 SURFACES = 125
SPEC	QMSI-6.2.2, B.O. REV D
DRAWN BY:	COLE
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 206A & B	
SCALE	1:1
DATE	4/25/2003
SHEET 2 OF 4	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0278	-4 CH'D DIM WAS .030 X 45° IS .03 X 45°, CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, DELETED WORK INSTRUCTIONS. ADDED DATUM A AND GD&T FEATURE CONTROL FRAME.	1/11/2017	RJC	JAG



TRUNNION INNER RACE REMOVAL PLUG

(-4)

DART AEROSPACE	
TITLE	
T/R TRUNNION CENTERING TOOLS	
DWG NO. RBT18517-4	
REV	2
MAT'L 4140/4142	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .005
TREAT	FRACTIONS ± 1/8
FINISH	.XX ± .01
SPEC	ANGLES ± 5°
QMSI-6.2.2, B.O. REV D	
DRAWN BY:	COLE
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 206A & B	
SCALE	1:1
DATE	4/25/2003
SHEET 3 OF 4	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0278	-5 CH'D DIM WAS .030 X 45° IS 2X .03 X 45°, CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, DELETED WORK INSTRUCTIONS.	1/11/2017	RJC	JAG



(-5)

TRUNNION BEARING RACE PLUG

DART AEROSPACE	
TITLE	
T/R TRUNNION CENTERING TOOLS	
DWG NO. RBT18517-5	
REV 2	
MAT'L 4140/4142	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	X ± .1 SURFACES = 125
SPEC QMSI-6.2.2, B.O. REV D	
DRAWN BY:	COLE
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 206A & B	
SCALE	2:1
DATE	4/25/2003
SHEET 4 OF 4	